



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4417-041
Job Sheet 174125



Part No: D4417-041

Job Qty: 1 ea

Part Name: Step Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/12/18

Job Tracking No:

Due Date: 3/14/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B SHEETS 3,4 IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC IPP REV:B 11.08.17 PER REV.B. DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/13/18	0.00	0.00	Start Up Large Fab-4		DC 2018-03-12
100	Large Fab	1 pcs		3/13/18	0.00	1.76	Large Fab 8		DC 2018-03-12
120	QC	1 pcs		3/13/18	0.00	0.00	QC5		CPL
130	HandFinish	1 pcs		3/13/18	0.00	0.36	HandFinish1		SA 18-3-12
140	QC	1 pcs		3/13/18	0.00	0.00	QC7-3		1.98
150	Large Fab	1 pcs		3/13/18	0.00	1.76	Large Fab 2		1.98 CPL
160	QC	1 pcs		3/13/18	0.00	0.00	QC10		38 DAS
170	QC	1 pcs		3/13/18	0.00	0.00	QC5		9-89 38
180	Powdercoat	1 pcs		3/13/18	0.00	0.26	Powdercoat1		BR 18-3-13
190	HandFinish	1 pcs		3/14/18	0.00	0.36	HandFinish3		BR 18-3-14
200	QC	1 pcs		3/14/18	0.00	0.00	QC3		14 13-3-14
210	Packaging	1 pcs		3/14/18	0.00	0.00	Packaging3-2		14 13-3-14
220	QC21-SA	1 Ea		3/14/18	0.00	0.00	QC21		DAS 21 MAR 14 2018

Part Op 100 - 1-Cut D2622 to 106"AS PER DWG 2-DRILL HOLES USING DT9765 3-CUT ENDS AT 45 DEG AS PER DWG
Descriptions: 150 - 1-SWAGE TUBES AS PER DWG 2-Weld cap per dwg D4417 3-grind flush

180 - 1-Touch up alodine

220 - 4- OPEN HOLES AT 0.508" AS PER DWG

M 138760 START: NIS OUT: 320° FINISH: 4/4/15.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	1 Ea (1 ea)	90-Start up Operation	5046116
D2734	Step End Plate	2 Ea (2 ea)	150-Large Fab	5012001
D4425-1	Step Spacer	2 Ea (2 ea)	150-Large Fab	140054

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	1	231	0
150-Large Fab	D2734	2	21	0
	D4425-1	2	10	0

001602

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Part Specifications
Specifications could not be found.

Plex 3/12/18 7:33 AM dart.lacelle.linda

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

DART Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

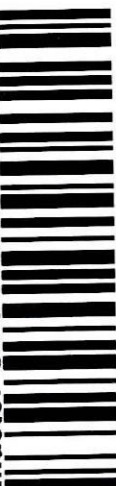
Interr

Tribz

Pas

Date: 03/12/18

Master Unit 001569



Job No 174125

Container No: S050153



Part: D4417 - 041

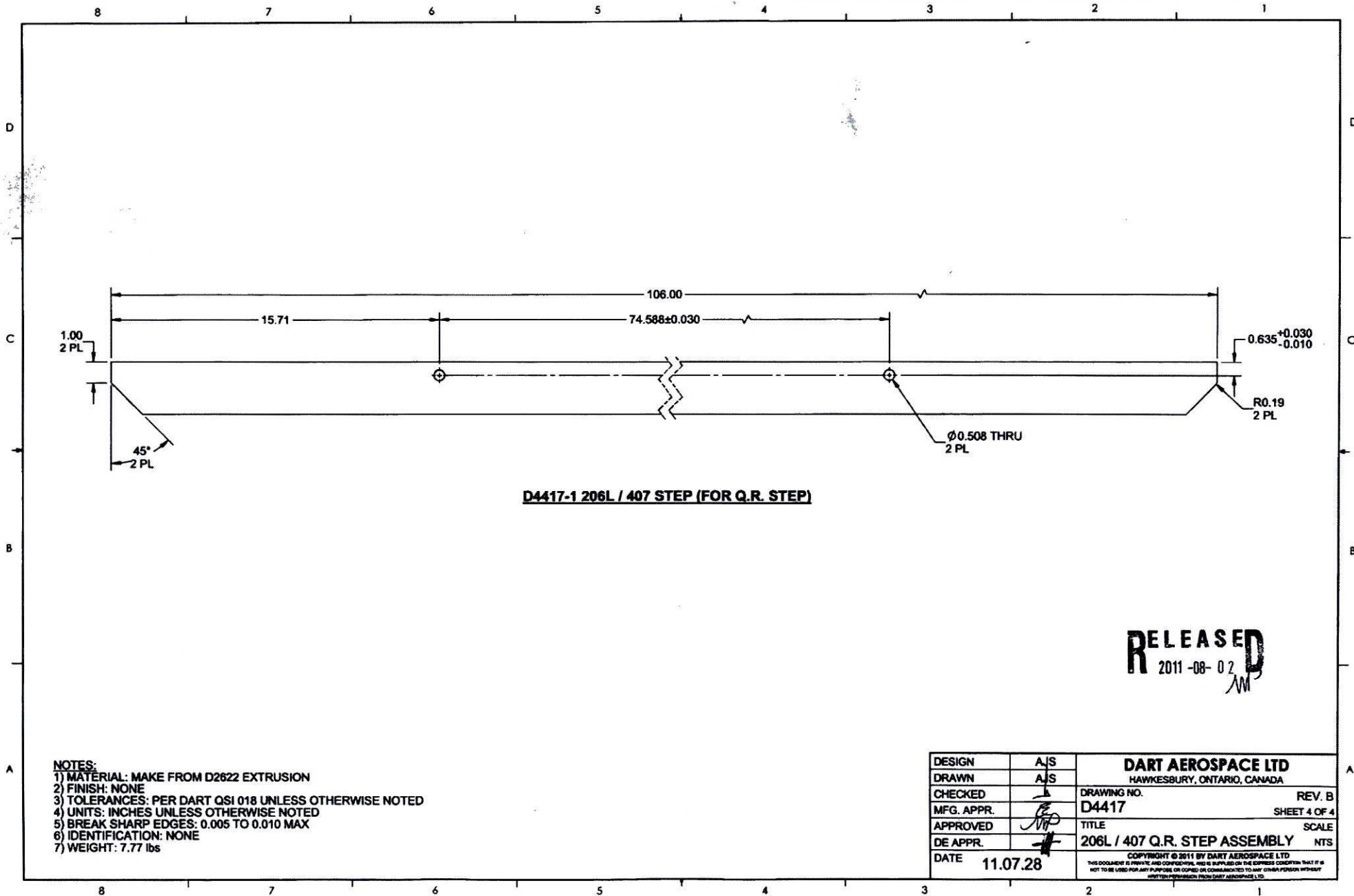
Job No: 174125

Serial No/Batch: S050153

Revision:

Inspector:

arge	☐	Positioned Wrong
	☐	Outside Dimensions
	☐	Over/Under tolerance
	☐	Part Incorrect
ulled	☐	Part Lost/Missing
ce	☐	Part Moved
	☐	Drawing
	☐	Finish
	☐	Misread
center	☐	Turning Sequence



- NOTES:**
- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 7.77 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4417	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		206L / 407 Q.R. STEP ASSEMBLY	NTS
DATE	11.07.28	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS TO BE SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2011-08-02